

OK 1/14/21

Work Order ID 111726

January-20-14 2:42:17 PM

Page 1

~~PRELIMINARY ISSUE~~ \*111726\*

Item ID: D5018-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: PRELIM Stop \*NS2\*  
 Item Name: Support, 214 Aft

Start Date: 1/20/14 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 2/03/14 Req'd Qty: 4.00 \*4\* Customer:

Reference: *14.01.21*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5018	A

100	HAAS CNC VERTICAL MACHINING #1	0.00							
*100*									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FB249								
	Folio Rev: <u>AA</u>								
	Dwg Rev: <u>A</u>								

Deburr

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

PTO

DQA:

Date: 14/03/07

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date: 14-2-28

Work Order update only ☐

Work Order: <u>111726</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D5018-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3566</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator	14/02/05	100	1	→ Dimension .140 - .180 is .132 on 1 part	DAS 12 9-89	Acceptable.		.AS 27 9-89	DAS 16 9-89
Offset/Setup				→ Ran the 2 origin at 0 and had to raise .025"	14/2/5	No effect on fit or strength	B.A 14/02/05	14/02/06	14/02/05
Process	<input checked="" type="checkbox"/>			R.C. operator error					
Supplier				New Program. change					
Training									
Transport									
Unapproved									

with out correct Document **FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input checked="" type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 111726

**\*111726\***

Page 2

January-20-14 2:42:17 PM

Item ID: D5018-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: PRELIM Stop **\*NS2\***  
 Item Name: Support, 214 Aft  
 Start Date: 1/20/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 2/03/14 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 27 0.00 9-89 14/2/16				4			
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00							<i>[Signature]</i>
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

**POSITIVE RECALL**  
 EFFECTIVE 140210 AUTH [Signature]  
 RELEASED [Signature] DATE 140226

Release Dwg to Rev A  
 MJS 14-02-26  
 MK 14-2-10

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

January-20-14 2:38:29 PM

Page 1

Work Order ID: 111726

**\*111726\***

Parent Item: D5018-1

**\*D5018-1\***

Parent Item Name: Support, 214 Aft

Start Date: 1/20/14

Required Date: 2/03/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A NEW ISSUE JFS 14/01/20 VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D5018-1TRN

Manufactured No

100

Each

0.0000

1

4

**\*D5018-1TRN\***

Support, 214 Aft

**\*\***

B.a 14/02/04

→ M 111724

2.0

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

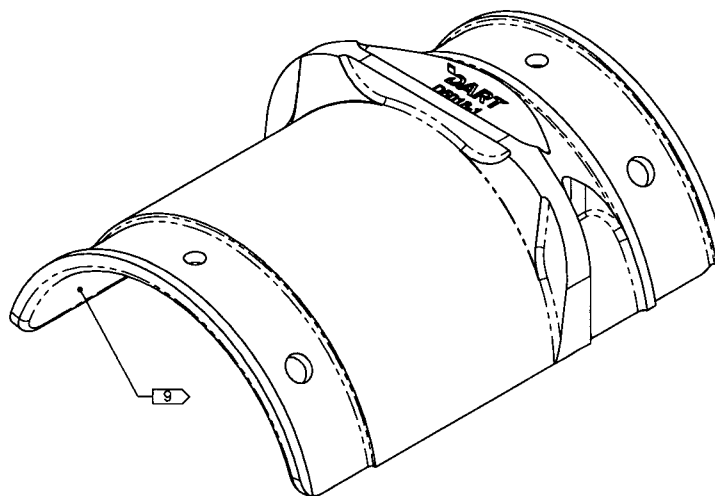
Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
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		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



**D5018-1 SUPPORT, 214 AFT**

**NOTES:**

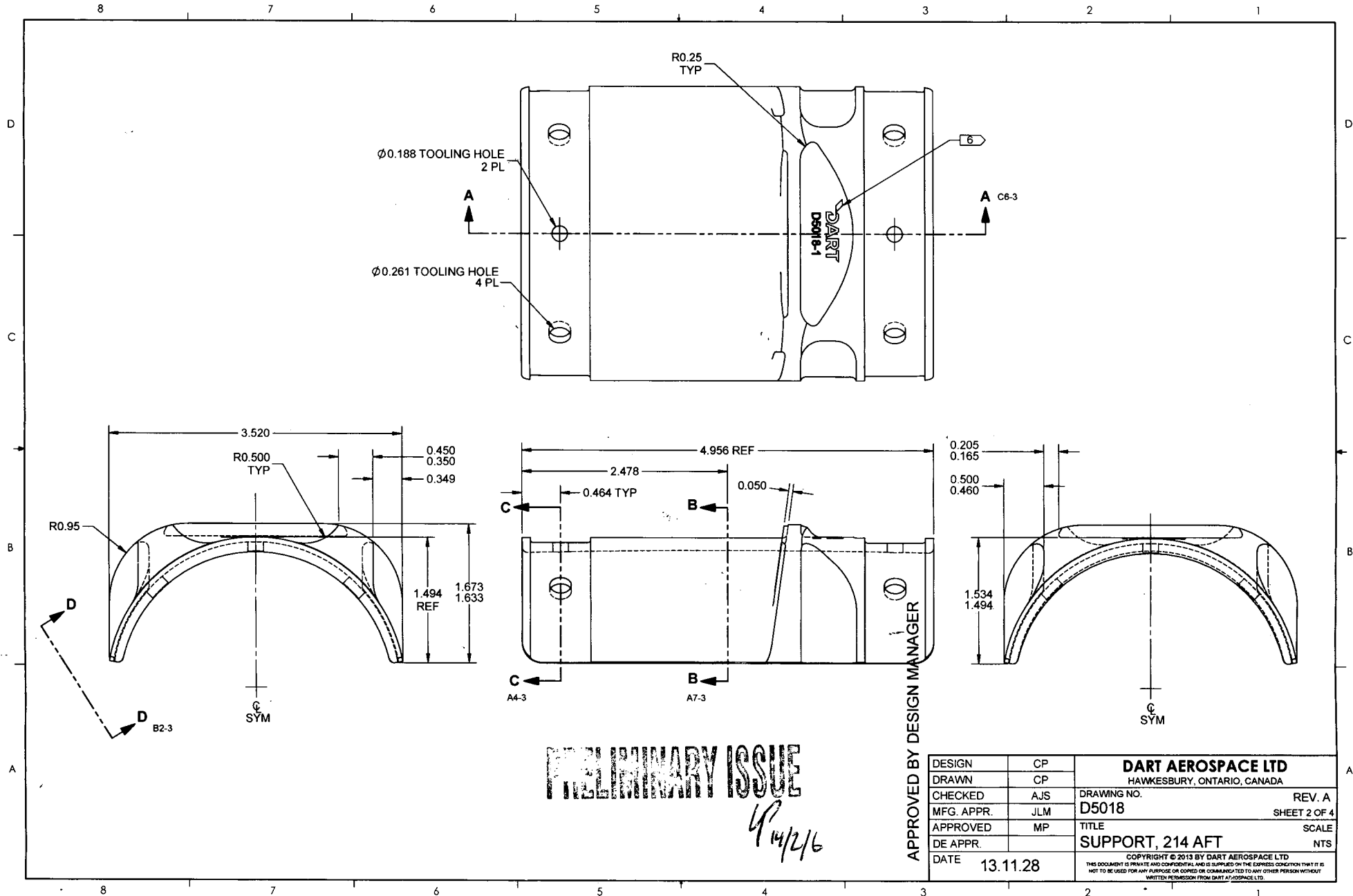
- 1) MATERIAL: MAKE FROM D5018-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N "D5018-1" IN THIS AREA WITH 0.125 HIGH X 0.010-0.020 DEEP LETTERING  
PER DART QSI 044 6.3
- 7) WEIGHT: 1.07 lbs
- 8) INNER CONCAVE SURFACE HAS A CONSTANT RADIUS OF R1.637 (REF) CUT ALONG AN R103.6 (REF) PATH (ie. TORUS SHAPE)
- 9) FOR ENTIRE INNER CONCAVE SURFACE: ABRASE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIV.).  
APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE  
FOR 24 HOURS.

APPROVED BY DESIGN MANAGER

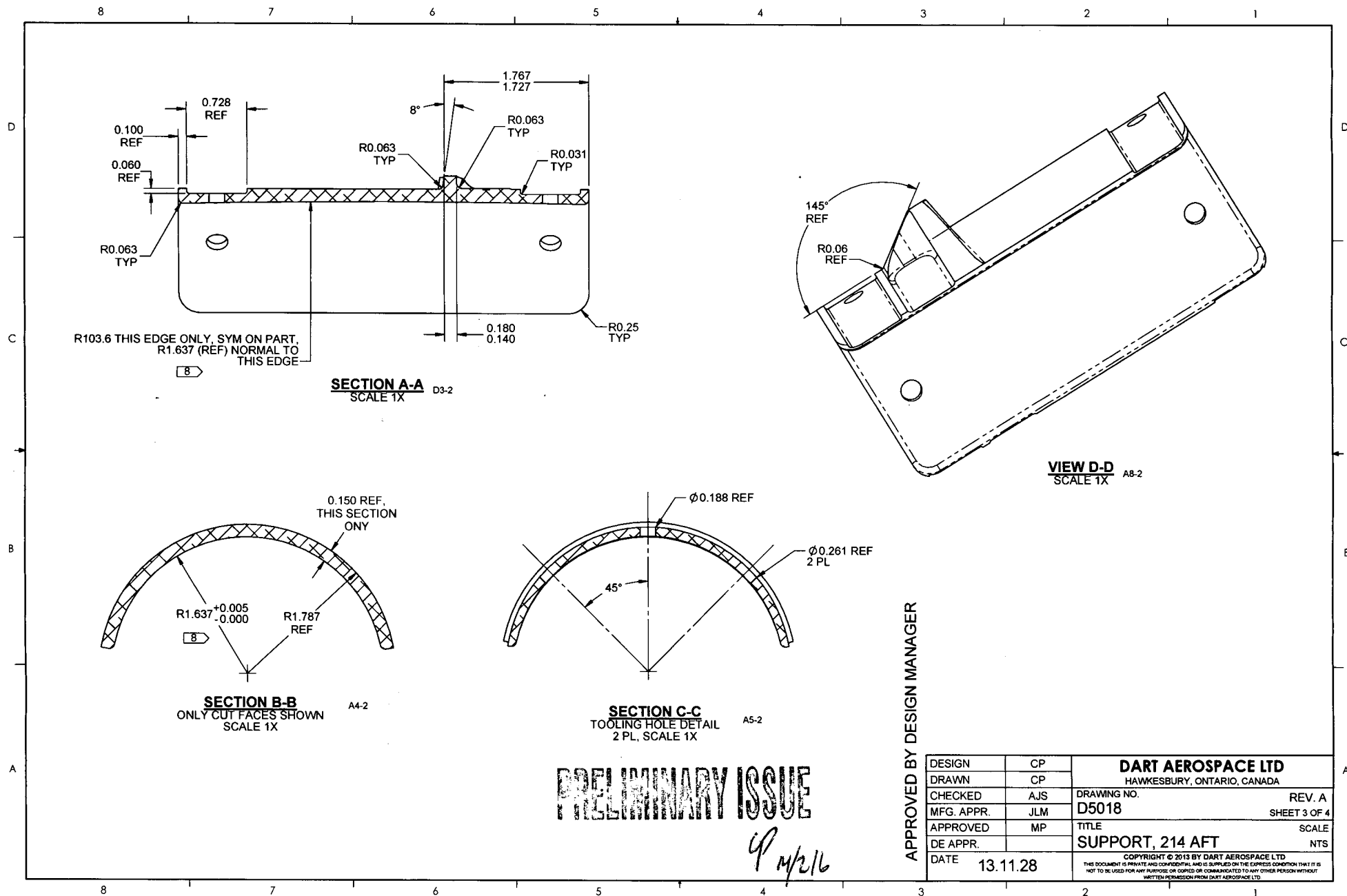
**PRELIMINARY ISSUE**

*CP 11/2/6*

A		NEW ISSUE		CP	13.11.28
REV.	DESCRIPTION			BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	CP				
CHECKED	AJS	DRAWING NO.	REV. A		
MFG. APPR.	JLM	D5018	SHEET 1 OF		
APPROVED	MP	TITLE	SCALE		
DE APPR.		SUPPORT, 214 AFT	NTS		
DATE	13.11.28		COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

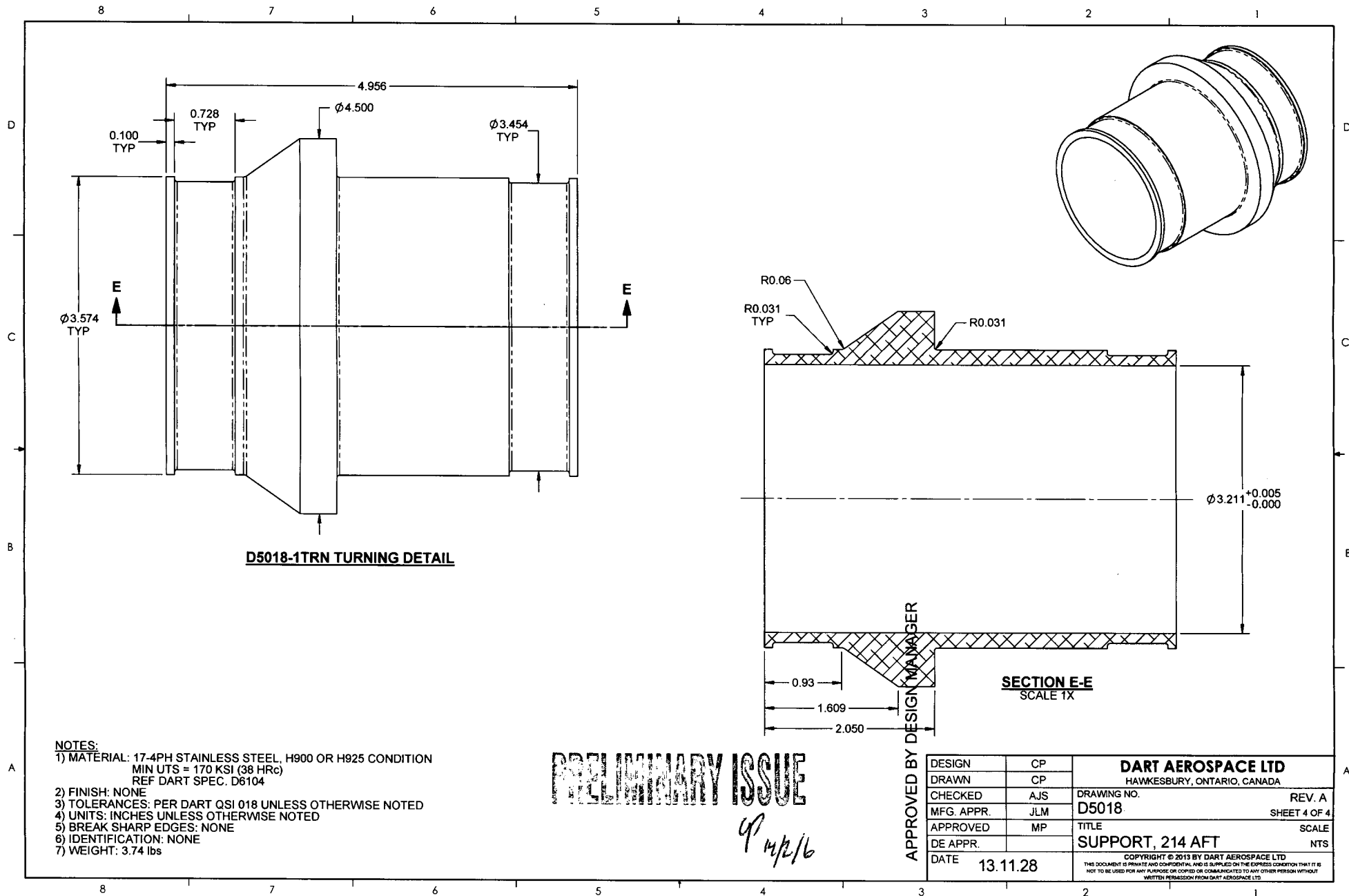






APPROVED BY DESIGN MANAGER

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	AJS	DRAWING NO. <b>D5018</b>	REV. A
MFG. APPR.	JLM	SHEET 3 OF 4	
APPROVED	MP	TITLE	SCALE
DE APPR.		<b>SUPPORT, 214 AFT</b>	NTS
DATE	13.11.28	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	111726
<b>Description:</b> Ø Support		<b>Part Number:</b>	D5018-1
<b>Inspection Dwg:</b> D5018		<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
<b>HAAS Section</b>								
AA	Ø .187	Ø .193		Ø 0.189	0.189	0.189	0.189	
AB	Ø .260	Ø .267		0.261	0.261	0.261	0.261	
AC	3.510	3.530		3.512	3.512	3.510	3.510	
AD	.350	.450		0.445	0.445	0.445	0.445	
AE	.339	.359		0.340	0.340	0.340	0.340	
AF	1.633	1.673		1.658	1.660	1.660	1.660	
AG	.454	.474		0.462	0.462	0.462	0.462	
AH	2.468	2.488		2.478	2.478	2.478	2.478	
AI	.040	.060		0.050	0.050	0.050	0.050	
AJ	.165	.205		0.170	0.170	0.170	0.170	
AK	.460	.500		0.475	0.475	0.475	0.475	
AL	1.494	1.534		1.498	1.499	1.500	1.500	
AM	R0.053	R0.073		0.063	0.063	0.063	0.063	
AN	1.727	1.767		1.729	1.753	1.752	1.750	
AO	R0.053	R0.073		0.063	0.063	0.063	0.063	
AP	R0.220	R0.280		0.250	0.250	0.250	0.250	
AQ	0.140	0.180		0.132	0.152	0.152	0.152	
AR	0.140	0.180		0.152	0.150	0.150	0.150	
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								

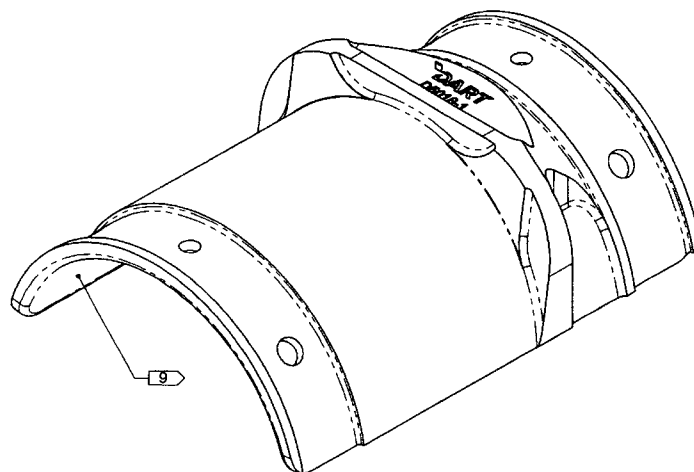
check NCR  
acceptable

Ensure that Ø " bore is perpendicular to " bore within "

Accept/Reject

<b>Measured by:</b> B.A.	<b>Date:</b> 14/02/04
<b>Audited by:</b>	<b>Date:</b> 14.2.04
<b>Preliminary Approval:</b>	<b>Date:</b> 12/2/04

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	



**D5018-1 SUPPORT, 214 AFT**

**RELEASED**  
2014-02-10

**NOTES:**

- 1) MATERIAL: MAKE FROM D5018-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 7) WEIGHT: 1.07 lbs
- 8) INNER CONCAVE SURFACE HAS A CONSTANT RADIUS OF R1.637 (REF) CUT ALONG AN R103.6 (REF) PATH (ie. TORUS SHAPE)
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A	NEW ISSUE		CP	13.11.28
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CP			
CHECKED	AJS		DRAWING NO.	REV. A
MFG. APPR.	JLM		D5018	SHEET 1 OF 4
APPROVED	MP		TITLE	SCALE
DE APPR.	DS		SUPPORT, 214 AFT	NTS
DATE	13.11.28		COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

APPROVED



